



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

U/R

D3512-041
Job Sheet 200914



Part No: D3512-041

Job Qty: 12 pcs

Part Name: Wearplate



Part Weight: 0 lbs

Status: New

Job Created: 9/19/19

Job Tracking No:

Due Date: 10/7/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF 18-745 DWG D3512-REV.D IPP REV:A 13.07.19 NEW ISSUE DD VERF:JLM IPP REV:B 13.12.11
ECN13-619/ REV.D DWG DD VERF:JLM IPP REV:C 18.03.12 DWG REV.E12 DD VERF:JFS IPP REV:D
18.10.12 BACK TO REV.D DD VERF:RG

Ship Via:

POSITIVE RECALL

EFFECTIVE 10/02/2019 AUTH SP

RELEASED 68 DATE OCT 02 2019
9-89 Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
110	Large Fab - Welded Assy-1	12 pcs	10/7/19		0.00	2.00	Large Fab - 1		EL
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
120	Large Fab - Welded Assy-2-B4B	12 pcs	10/7/19		0.00	2.00	Large Fab - 1 - B4B		mf
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
							Large Fab - 9 - B4B		
							Large Fab - 11 - B4B (Various)		
			10/7/19		0.00	0.00	QC 9 - 10		EL
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
			10/7/19		0.00	0.00	QC 5 - 10		

PRIORITY



Container No: S217889



Part: D3512-041

Job No: 200914

Serial No/Batch: S217889

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/27/19

Plex 9/19/19 9:40 AM Dart.lajeunesse.marie

				pcs		QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	22
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
142	Spray Paint - 2 - B4B	12	10/7/19	0.00 1.20		Spray Paint - 1 - B4B	
	pcs					Spray Paint - 2 - B4B	RD19-9-30
						Spray Paint - 3 - B4B	
						Spray Paint - 4 - B4B	
144	QC 5	12	10/7/19	0.00 0.00		QC 5 - 10	
	pcs					QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	OCT 02 2019
						QC 5 - 61	DAS 40 9-89
						QC 5 - 81	
150	Packaging 3-1 - Stock - B4B	12	10/7/19	0.00 0.00		Packaging 3 - 1 - B4B	
	pcs					Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	DAS 28 9-89
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	12 pcs	10/7/19	0.00 0.00	QC 21 - SA - 21	DAG
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

Part Op 110 - Weld per dwg A/R Hardcoat S.S. Batch: 2059B HARDCOAT BATCH: 139018
 Descriptions: 120 - Weld per dwg A/R S.S. rod Batch: 136585
 130 - QC9- Inspect visual per QSI004- Fusion Welds
 140 - QC5- Inspect part completeness to step on W/O
 142 - Assemble as per dwg - Coat wearplate with rockguard as per Dwg and note #10 Batch: 5287093
 144 - QC5- Inspect part completeness to step on W/O
 150 - Identify as per dwg & Stock Location: _____
 160 - QC21- Final Inspection - Work Order Release

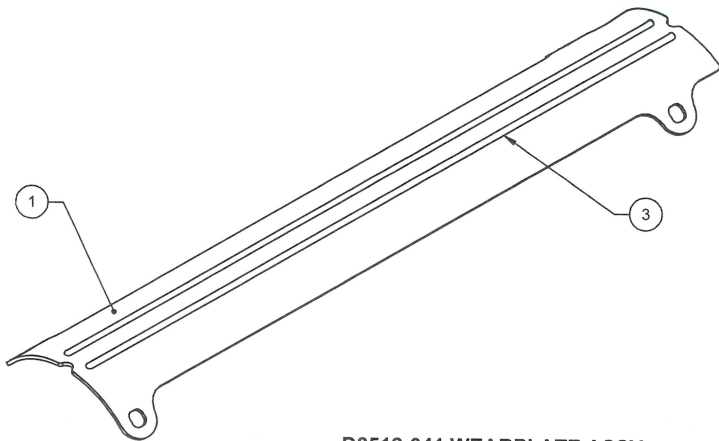
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3512-1	Wearplate	12 pcs (1 ea)	110-Large Fab - Welded Assy-1	5217451
D3512-3	Spacer	12 pcs (1 ea)	110-Large Fab - Welded Assy-1	5217469

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	D3512-1	12	0	0
	D3512-3	12	16	0

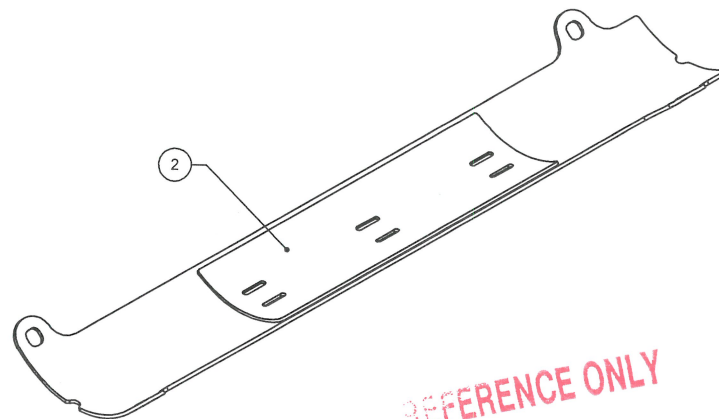
Part Specifications
Specifications could not be found.

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ITEM	QTY	P/N	DESCRIPTION
	X	D3512-041	WEARPLATE ASSY
1	1	D3512-1	WEARPLATE
2	1	D3512-3	SPACER
3	A/R	8259 \ 2059B	HARD SURFACING



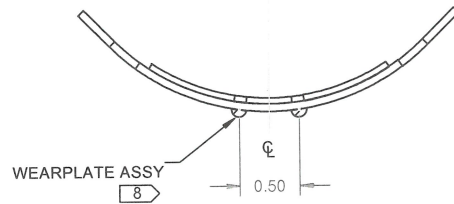
D3512-041 WEARPLATE ASSY



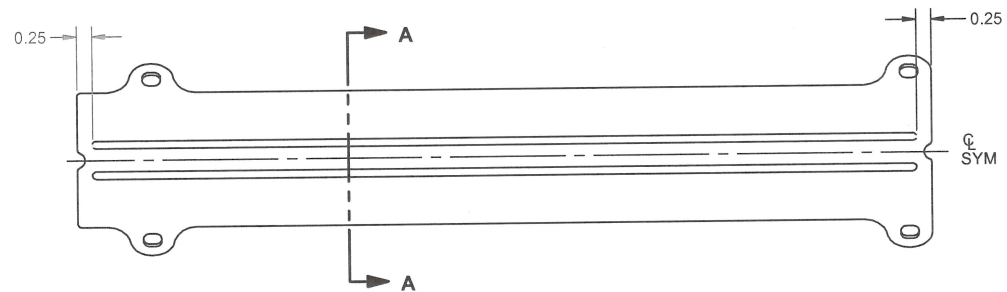
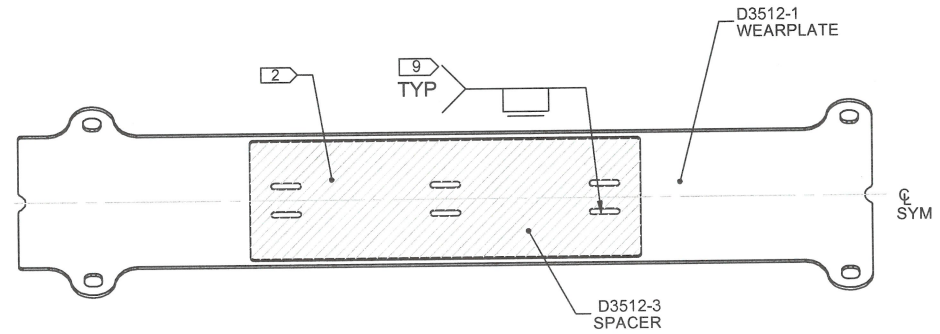
E	ADJUSTED WIDTH OF PART FOR FIT AND FUNCTION, DIM 3.83 WAS 3.84 (ZN D3-3). UPDATE NOTE 8 (ZN A8-2). ADD NOTCHES (ZN D3-3 & D8-3). CHANGE SLOTS TO QTY 6 AND LENGTH TO 0.5 (ZN D4-4). GENERAL UPDATE OF DRAWING TO CURRENT STANDARDS.	SAD	18.03.07
D	ADD D3512-041 AND D3512-3	DW	13.08.28
C	ENLARGE OBOUND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE

WORK IN PROGRESS

DESIGN	DW	DART AEROSPACE USA, INC. HILLSBORO, OR	
DRAWN	SAD		
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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SECTION A-A 
SCALE 2X



D3512-041 WEARPLATE ASSY

REFERENCE ONLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT HATCHED (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.87 lbs
- 8) APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) WELD PER QSI 004

WORK IN PROGRESS

DESIGN	DW	DART AEROSPACE USA, INC.	
DRAWN	SAD	HILLSBORO, OR	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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8

7

6

5

4

3

2

1

D

C

B

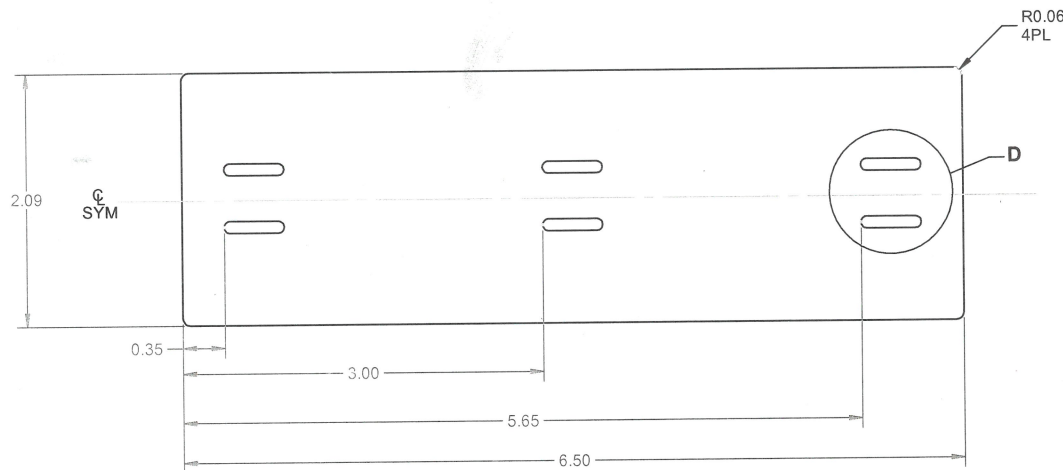
A

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B

A

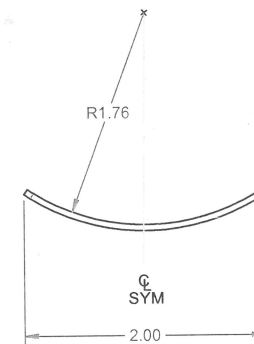


D3512-3F SPACER 
(FLAT PATTERN)

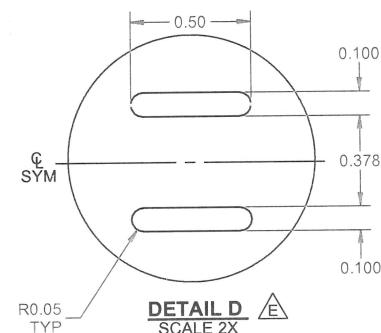
REFERENCE ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 18 GAUGE 0.050 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. MS304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs



D3512-3 SPACER
(MAKE FROM D3512-3F)



WORK IN PROGRESS

DESIGN	DW	DART AEROSPACE USA, INC.	
DRAWN	SAD	HILLSBORO, OR	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. 19-27517

Route update only

Job: <u>8 200914</u> Part No. <u>D3512-041</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐				☒ Engineering ☐ Water Jet ☐ Supplier ☐ Quality																											
Date: <u>19/09/26</u>		Sequence #: <u>110</u>		QTY Affected: <u>6076</u>		MRB (QS1042) DAS 51 9-89 <u>19/09/26</u>																													
Description Work Order Deviation				Disposition																															
USE D3512-041 Rev. E to assemble D3512-1 and D3512-3 at Rev. E minor change to Rev. D flat patterns for manufacturability, No change to final bent wearplate Ref 201457				-Acceptable to use Rev. E D3512 Rev. E is a minor change from D3512-Rev D -this change is to fix a fit issues Ref. w/o 192599 sign by CP																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☒ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>				☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☒ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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Other/Details:																																			

Completed By

Lead hand / Supervisor

QC / QA Coordinator

OCT 02 2019